



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

5219
Nov 10

C10-12-0
Job Sheet 184507



Part No: C10-12-0

Job Qty: 12 ea

Part Name: Solenoid



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/11/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG C10-12 Rev 2 IPP Rev A 18.04.10 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		11/9/18	0.00	0.00	Start Up Machining-4		
100	Mill Conv	12 pcs		11/9/18	0.50	2.40	Mill Conv 2		
110	QC	12 pcs		11/9/18	0.00	0.00	QC2 Machining-5		
120	QC	12 pcs		11/9/18	0.00	0.00	QC8 Machining-5		
130	Packaging	12 pcs		11/9/18	0.00	0.00	Packaging3-2		
140	QC21-SA	12 Ea		11/9/18	0.00	0.00	QC21		

Part Op 100 - 1-Drill hole in shaft. Shaft should be retracted when drilled. Studs facing you rotate shaft COUNTER clockwise to the
Descriptions: end of stroke, push shaft into solenoid then drill as per DWG sheet 2 2-Engrave S/N and/or P/N number using Marktronic engraver as per DWG.

GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
H-2553-020	Solenoid	12 Ea (1 ea)	90-Start up Operation	S083732

GA 186F

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	H-2553-020	12	23	0

Part Specifications

Specifications could not be found.



Container No: S123046



Part: C10-12-0

Job No: 184507

Serial No/Batch: S123046

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/31/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
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LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐				
Misidentified	☐	Past Due	☐	OTHER :			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

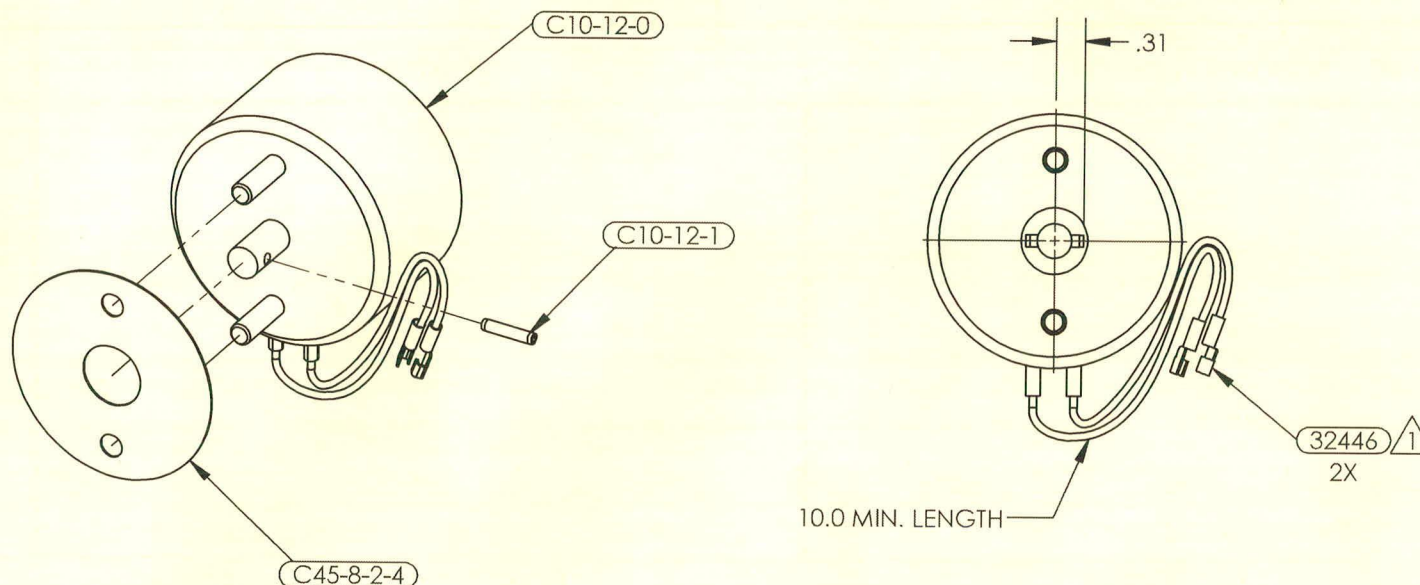
QA Closed: _____ Date: _____

Work Order update only ☐

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		AS DRAWN BY CANAM	5/13/2013	CFS	
2	14-0090	CH'D TITLEBLOCK WAS RED BARN IS DART. ADDED 10.0 MIN LENGTH NOTE. ADDED SPACER C45-8-2-4, & CONNECTORS 32446. C10-12-0 ADDED ENGRAVE BATCH NUMBER NOTE. C10-12-1 CH'D MAT'L WAS STEEL IS S.S., ADDED B/O INFO #92383A695.	7/25/2014	JAG	RW



NOTE:

1 CONNECTORS SUPPLIED LOOSE WITH ASSEMBLY.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		B/O	C10-12-0	1	SOLENOID		H-2553-020 (MODIFIED)	2
		B/O	C10-12-1	1	SPRING PIN	S.S.	Ø1/8 X 5/8 MCMaster-CARR #92383A695	1
			C45-8-2-4	1	SPACER		SEE DWG. C45-8-2	1
		B/O	32446	2	22-16 AWG KNIFE CONNECTOR		ALLIED ELECTRONICS 32446	1

DART AEROSPACE	
TITLE SOLENOID ASSY	
DWG NO. C10-12	REV 2
MAT'L	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D Weil</i>
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	HEAT TREAT FINISH
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC
SCALE 1:2	DATE 4/26/2002
SHEET 1 OF 2	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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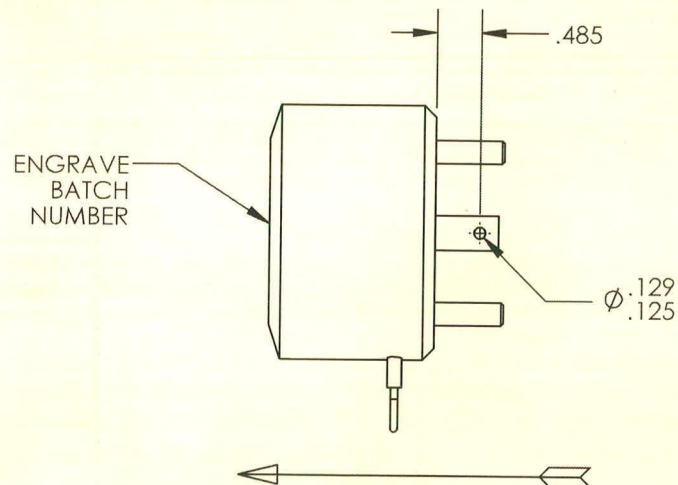
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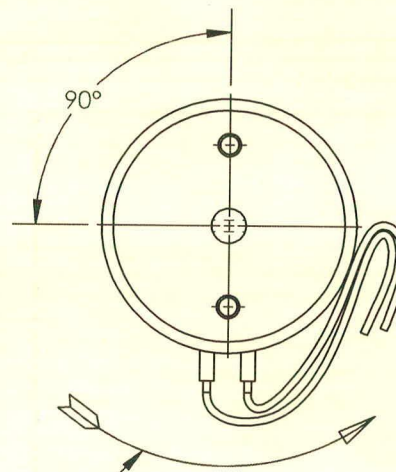
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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2	01-0090	C10-12-0 ADDED ENGRAVE BATCH NUMBER NOTE.	7/25/2014	DPD
			APPROVED	JAG

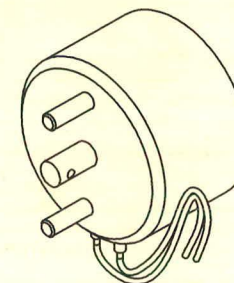
responsibl order num AUG 9ST descriptor responsibl order num AUG 9ST descriptor responsibl order num AUG 9ST descriptor responsibl order num AUG 9ST descriptor responsibl order num AUG 9ST



SHAFT SHOULD
BE RETRACTED
WHEN DRILLED



ROTATE SHAFT COUNTER-CLOCKWISE
(FACING THE STUDS) TO THE END OF STROKE
THEN DRILL AT 90° AS SHOWN.



(C10-12-0)

SOLENOID

DART AEROSPACE	
TITLE SOLENOID ASSY	
DWG NO. C10-12-0	REV 2
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: CANAM APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 12/19/2001
SHEET 2 OF 2	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								